

[illegible]

Wednesday, September 09, 2009 11:38:05 A

Accept

[illegible]**Setup Start**

Stop

[illegible]**Cust Item ID:**

1000

Customer:

Reference:

Run Start

Date:

Date:

Stop

**Insp.
Stamp**

Revision Nbr

Rev A

100

0.00

Abstract

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA628 & DWG D3490 □ FOLIO
REV: □ DWG REV: □ 2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

[illegible]

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

OC

Memo

0,00

Quality Control

Work Order ID 51932

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Page 2

Item ID: D3490-1

Accept

Revision ID: A

Item Name: Cross Bolt Spacer

Start Date: 9/11/2009 Start Qty: 40.00

Required Date: 9/25/2009 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

9/9/24 (40x) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/25 MF
MF 09-09-25

Picklist Print

Page 1

Wednesday, September 09, 2009 11:38:09 AM

Work Order ID: 51932



Parent Item: D3490-1RevA



Parent Item Name: Cross Bolt Spacer

Start Date: 9/11/2009

Required Date: 9/25/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	145.5300	11.2000			

6061-T6 RD Tube .500 x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

145.53

111028

37.53

111944

108

51014

11.2 DJP 09/09/09

DART AEROSPACE LTD		Work Order:	57932
Description: Crossbolt Spacer		Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

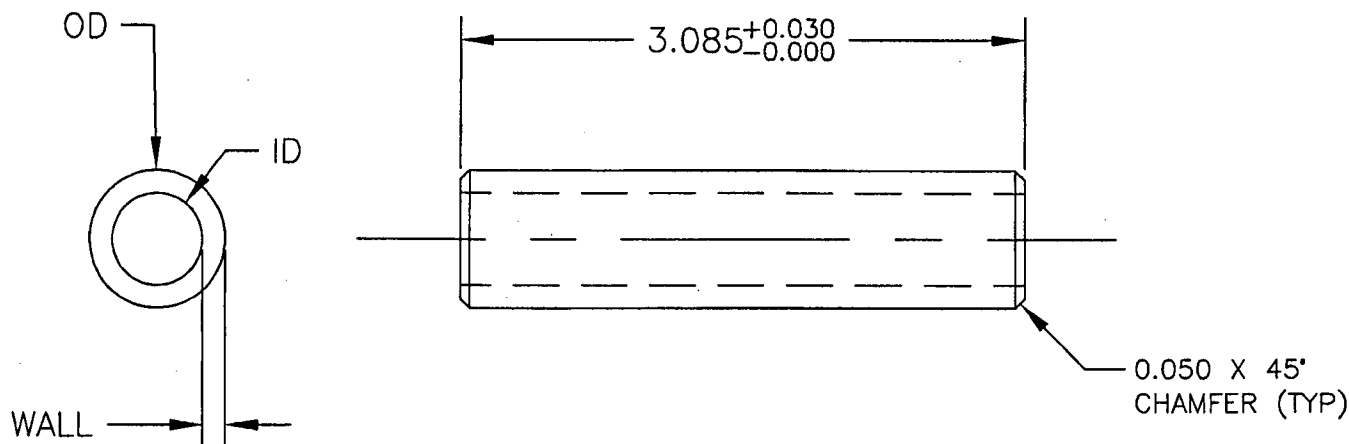
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	0.500	✓			
0.049	+/-0.010	0.049	✓			
Ø0.402	+0.006/-0.001	0.402	✓			
3.085	+0.030/-0.000	3.090	✓			
0.050 x 45°	+/-0.010	0.05 x 45°	✓			

Measured by:	DJP	Audited by:	JK	Prototype Approval:	N/A
Date:	09/07/24	Date:	09/09/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	08.06.02	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD	



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51932

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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